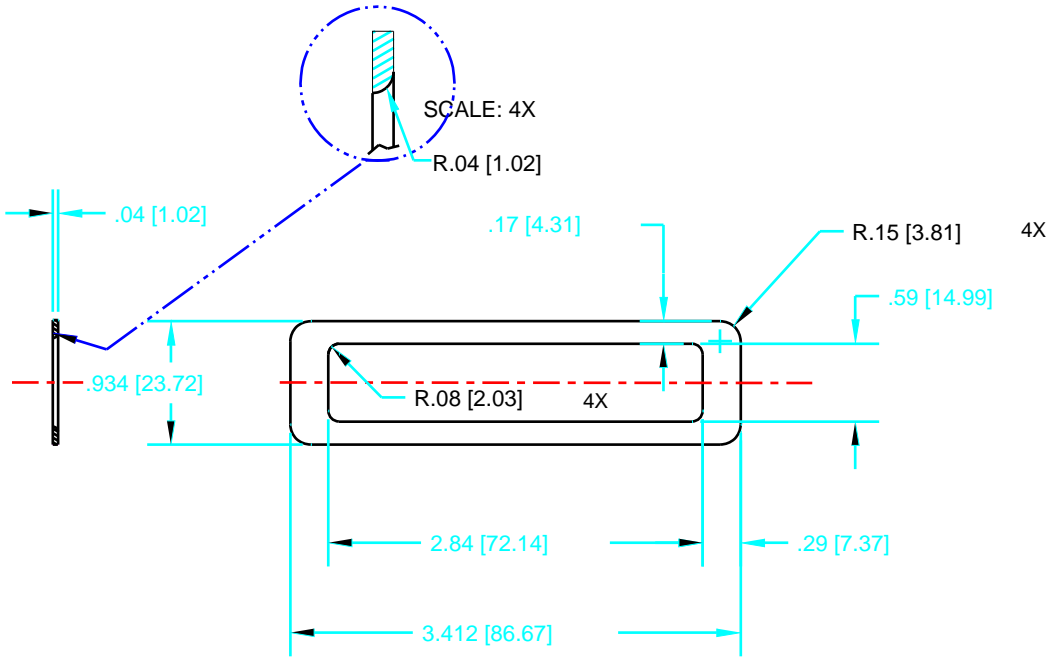


NOTES:

1. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTRO-POLISHING, THE PART MUST GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
2. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
3. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:

A) CIMCOOL 5 STAR 49

B) TRIM SOL
4. ALL DIMENSIONS WITH [] ARE MILLIMETERS AND FOR REF ONLY



ITEM		DWG/PART NUMBER		NOMENCLATURE OR DESCRIPTION				MATERIAL / SPEC		QTY									
PARTS LIST																			
<div>UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES</div> <div>TOLERANCES</div> <table><tr><th>DECIMALS</th><th>ANGULAR</th></tr><tr><td>.X - .03 [.7620]</td><td>- .25</td></tr><tr><td>.XX - .01 [0.25]</td><td></td></tr><tr><td>.XXX - .005 [0.127]</td><td></td></tr></table> <div>SURFACE ROUGHNESS 125 ✓</div> <div>REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.</div> <div>SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1</div> <div>DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5</div>				DECIMALS	ANGULAR	.X - .03 [.7620]	- .25	.XX - .01 [0.25]		.XXX - .005 [0.127]		LOG NUMBER		<div><div><div>ARGONNE NATIONAL LABORATORY</div><div>UNIVERSITY OF CHICAGO</div></div><div>THIS DRAWING IS THE PROPERTY OF</div><div>ARGONNE NATIONAL LABORATORY</div></div>					
				DECIMALS	ANGULAR														
				.X - .03 [.7620]	- .25														
				.XX - .01 [0.25]															
				.XXX - .005 [0.127]															
DRAWN BY		DATE		CHIEF DESIGN ENGINEER		DATE		TITLE											
FUHRMANN		6/15/94		D. SHU		10/13/94		ADVANCED PHOTON SOURCE											
CHECKED BY		DATE		GP LEADER		DATE		W3-20 BEAMLINE WINDOW											
J. WOTHE		10/12/94		T.M. KUZAY		10/13/94		6" O.D. (15 X 72)											
DESIGNER				PROJECT MGR.				BERYLLIUM WINDOW RETAINER											
D.SHU/FUHRMANN																			
RESPONSIBLE ENGINEER				APPROVED/RELEASED															
D.SHU				10/13/94															
MATERIAL						SCALE		SIZE		DRAWING NUMBER									
OFHC COPPER						1:1		B		P4105090803-200102-00									
DO NOT SCALE DRAWING						SHEET 1 of 1													

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

DO NOT SCALE DRAWING